

Date: Tuesday, 23/12/2008 9:43:03 AM
 User: Julie Dawson

Keep this original B# 40087

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D2582		
Job Number	: 44267		Part Number	: REWORK20		
Estimate Number	: 10804		Drawing Number	: NCR08-124		
P.O. Number	:		Project Number	:		
This Issue	23/12/2008	S.O. No. :	Drawing Revision	:		
Prsht Rev.	: NC		Material	:		
First Issue	11	Type : SMALL /MED FAB	Due Date	30/12/2008	Qty:	14
Previous Run	: 00015		Um:	Each		
Written By	:					
Checked & Approved By	: JUD 08.12.23					
Comment	:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2582	Step Leg Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s) Step Leg Assembly Pull from stock Qty 14 of B40087			
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	

Comment: SMALL & MEDIUM FAB RESOURCE 1

CAREFULLY remove all rivets on the D2279, to not enlarge or ovalize the holes.

*** Remove the rivet head, and carefully punch out the remainder of the rivet, to avoid drilling right through***

Touch up holes with alodine as necessary

3.0	QC5	INSPECT WORK TO CURRENT STEP	
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Comment: INSPECT WORK TO CURRENT STEP

(P14)

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Pick the following

5.0	MS20470AD44	Rivet, Universal Head	
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 140.0000 Each(s)

Rivet, Universal Head

1109545

(P14)

(P14)

(P14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 09/01/07

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/02	20	# part, D2278 needs 2 rivet holes filled with weld. slightly ob+round. R.c: Hit with punch while removing rivets for re-work	08/01/02	Drill the 2 affected holes with weld per QSI 004 + bring smooth & flat. Transfer drill & debur holes.	09/01/05	09/01/05	08/01/02	10/01/02
			08/01/02	Touch-up with paintline per QSI 005.	09/01/05		08/01/02	

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D2279

Step Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)
Step Spacer

*** Pick if necessary***

B_____

Qty:_____

1/4

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2582 and

EP 09/01/06 14

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/06 14

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

Keep Original Batch number

SAD 09-01-07 14

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 09/01/07 14

Job Completion



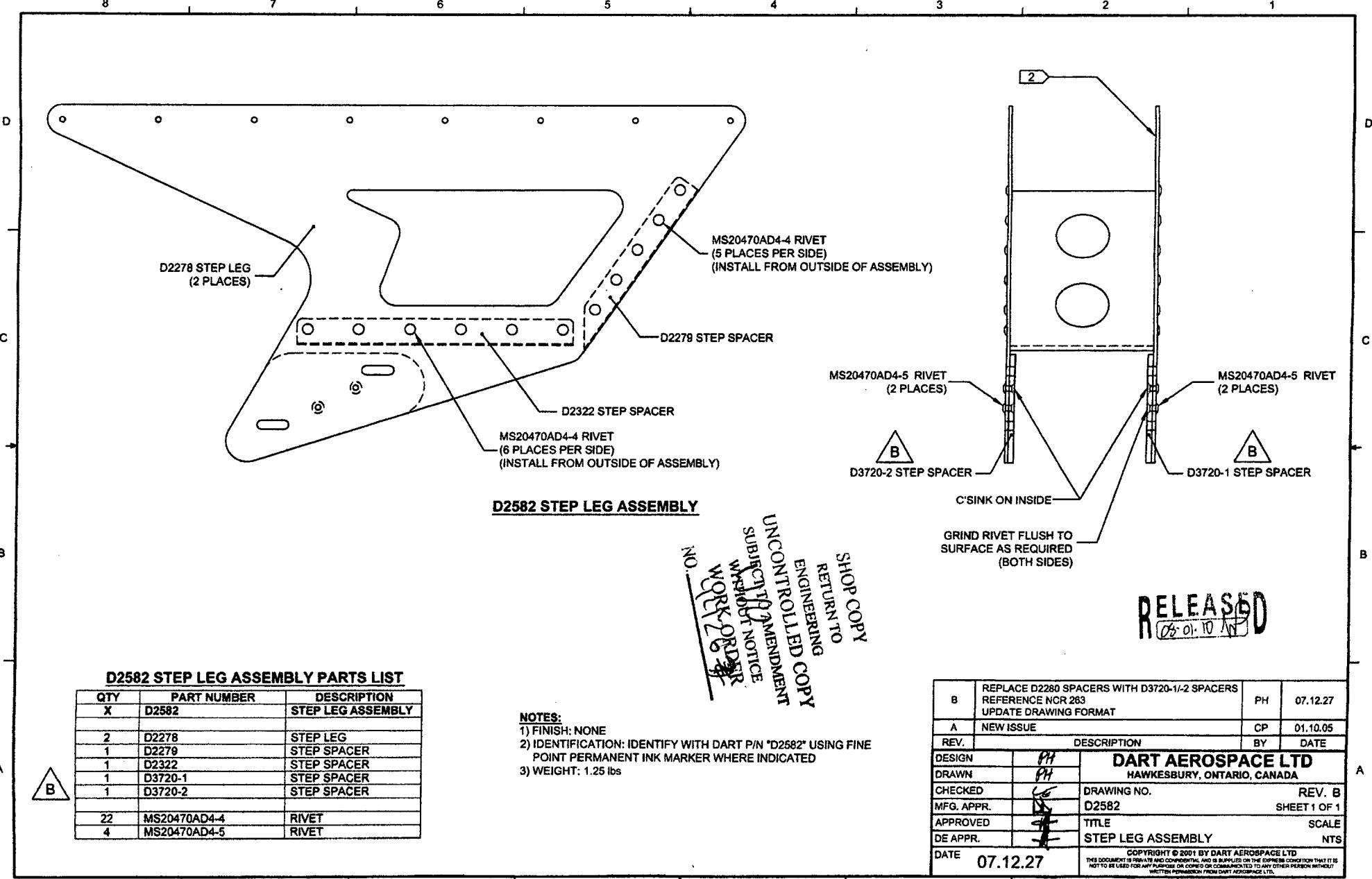
MF 09-01-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



140 rivets.

